

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017387**Date Inspected:** 12-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

FCAW welding of weld is identified as 1G-018 of BK004A2-001 for BK006A-001. The welder is identified as 062734. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2331-B-L1b-F-1.

FCAW welding of weld is identified as 1G-008 of BK004A1-007 for BK004A-007. The welder is identified as 062755. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of plug weld is identified as 2G-015 of BK004A2-010 for BK004A-010. The welder is identified as 259902. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2132-2-Plug.

FCAW welding of weld is identified as 1G-003 of BK4ASD1-004 for BK004A-004. The welder is identified as 062762. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2231-Tc-U4c-F.

FCAW welding of weld is identified as 1G-008 of BK004A1-009 for BK004A-009. The welder is identified as 062783. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld is identified as 3F-002 of BK004A2-010 for BK004A-010. The welder is identified as 062808. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133.

This QA inspector performed VT of cleanliness of welds and internal areas of Bike path BK004A-001. Areas requiring additional grinding and cleaning were marked by QA and repaired by ZPMC personnel. During VT found a stiffener missing in Stringer plate is identified as BKX9C. ZPMC has to do fillet weld and NDT on that weld joint and re offer for cleaning.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A2-008-016 (Side –B only)

BK004A2-007-016,018 (Side –B only)

BK004A2-006-016,018 (Side –B only)

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-012

BK004A3-012-002,010.

BK004A5-012-005.

BK004A5-012-008- Reject able class A indication found.

BK004A-005

BK004A3-005-002,010.

BK004A5-005-005,008.

BK005A-001

BK005A3-001-002,010.

BK005A5-001-005,008.

BK006A-002

BK006A3-002-002,010.

BK006A5-002-005,008.

BK004A-001

BK004A3-001-002,010.

BK004A5-001-005,008.

BK004A5-001-008.

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Bike path BK004A-012, this Quality Assurance Inspector (QA) discovered the following issue:

-One (1) Class “A” rejectable indication measuring approximately 40mm in length

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

For more information then please see the Incident report

04-0120F4_TL-15_B247_10-12-10_BK004A-012_UT_Rejectable_Indication

BAY#15

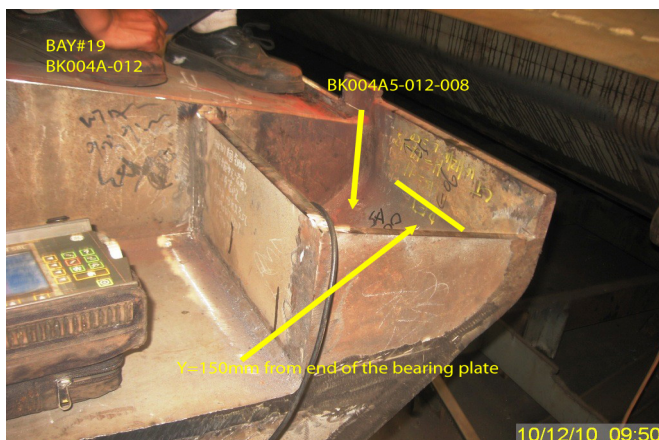
This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Segment 13E. The weld designations reviewed as follows.

KP3007-001-002,004,006,008.

KP3002-001-001~005.

KP3008-001-002,004,006,008,009.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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